

Date: Tuesday, 10/02/2009 11:09:21 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACER
 Job Number : 45675
 Estimate Number : 13580
 P.O. Number :
 This Issue : 10/02/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D38161
 Drawing Number : D3816 REV A
 Project Number : N/A
 First Issue : / / Type : MACHINED PARTS Drawing Revision : A
 Material :
 Previous Run : 42077 Due Date : 20/02/2009 Qty: 20 Um: Each
 Written By :
 Checked & Approved By : JD 09-02-10
 Comment : Est Rev:A New Issue 08-09-17 JLM Verified By:EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6T0375W058

6061-T6 RD Tube .375 x.058W



Comment: Qty.: 0.1050 f(s)/Unit Total : 2.1000 f(s)
 6061-T6 Tubbing .375" X .058" WALL
 Batch: M110485

SA 09/02/14

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE Lathe

1- Turn as per Folio FA784Rev: _____ & Dwg D3816 Rev: A

2-Deburr per dwg D3816

SA 09/02/14

(21)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 09/02/14

(21)

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 09/02/17 (21)

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

BR 09-02-17 24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/02/2009 11:09:21 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 45675

Part Number: D38161

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-02-18 20

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

P-4/1/8 21

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/19 18

Job Completion



mf
09-02-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

D

C

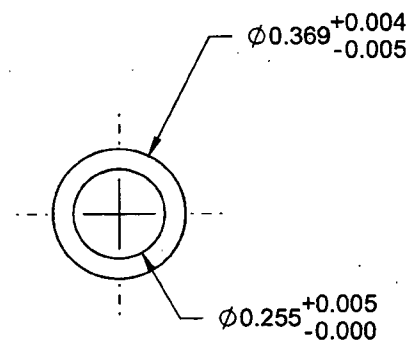
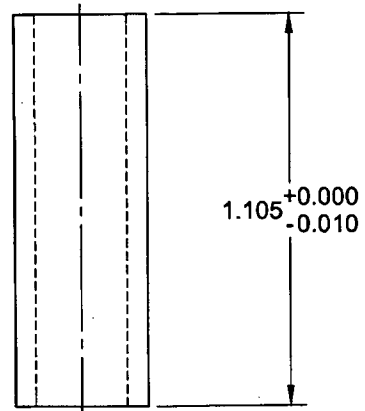
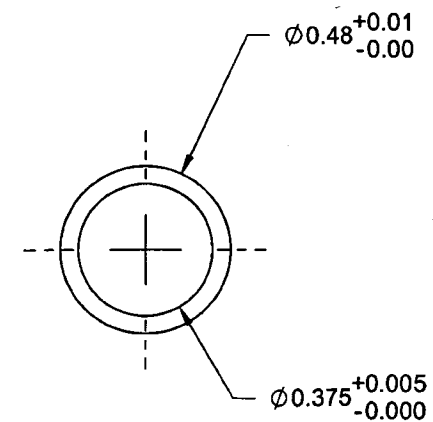
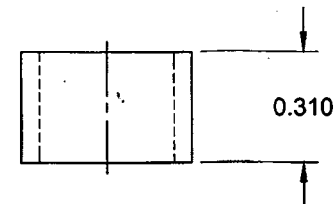
C

B

B

A

A

**D3816-1 SPACER****D3816-3 SPACER****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3816-1/-3 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3816-1 0.01 lbs
D3816-3 0.01 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45625

RELEASE
09/01/13

A	NEW ISSUE	BY	08.09.17	
REV.		DESCRIPTION	DATE	
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED			DRAWING NO.	REV. A
MFG. APPR.			D3816	SHEET 1 OF 1
APPROVED			TITLE	SCALE
DE APPR.			SPACER	NTS
DATE	08.09.17		COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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